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Method and apparatus for displaying ladder diagrams.

An apparatus for displaying a ladder diagram in a numerical control system having a programmable sequence controller function in which sequence processing is executed based on a sequence program to deliver commands from a numerical control device to a machine and signals from the machine to the numerical control device, as well as a function for displaying the sequence program in the form of a ladder diagram composed of at least relays, and for displaying storage locations of a data memory at each of which an operating state of a respective relay is stored, each storage location appearing in the vicinity of the relay corresponding thereto. Corresponding relationships are established between data memory locations storing the states (logical «1» or logical «0») of relays, and the identifications of the relays. The corresponding relationships are stored in memory. Then, by using these corresponding relationships, the identification of a desired relay is found and is displayed along with the relay, the identification appearing in the vicinity of the relay.

Identification		MF	M28		M03	
Symbol					○	
Address		66.1	67.8		10.2	

METHOD AND APPARATUS FOR DISPLAYING
LADDER DIAGRAMS

5

This invention relates to a method and apparatus for displaying a ladder diagram and, more particularly, to such method and apparatus for facilitating an understanding of programmable sequence controller processing during debugging or maintenance, and for facilitating such debugging or maintenance.

Numerical control systems permit various mechanical elements in machine tools to be controlled on the basis of commands issued by a numerical control device which incorporates an operator's panel. In such numerical control systems a hardwired switch network or so-called "magnetics" unit comprising a multiplicity of relays is connected between the numerical control device, commonly referred to as an NC device, and the machine tool. Prescribed ones of these relays are actuated in response to the commands issued by the NC device, whereby the prescribed elements of the machine tool are caused to operate in the manner specified by the commands. These commands may be entered directly from the operator's panel, or may be generated in response to programmed M-function and S-function instructions. Disadvantages encountered in the conventional systems of the above type are the large

size of the apparatus and the high cost entailed by the large number of relays, as well as poor reliability attributed to mechanical failure of the relays.

In view of the foregoing disadvantages, sequence
5 controllers, also known as programmable sequence controllers, are now the most widely used means for performing, through program processing, the function of the magnetics unit. A programmable sequence controller (referred to hereinafter as a PSC) according to the
10 prior art is illustrated in Fig. 1. Numeral 1 denotes a numerical control device, 2 the conventional PSC installed separately of the numerical control device 1, and 3 a machine tool. The numerical control device includes a paper tape 101a bearing machining commands
15 in punched form, a paper tape reader 101a' for reading the paper tape, a random access memory (RAM) 101b for storing the machining commands read in from the paper tape 101a, a read-only memory (ROM) 101c storing a control program for controlling the numerical control
20 device 1, a central processing unit (CPU) 101d for executing processing in accordance with a machining command program or the control program, a transceiver unit 101e, such as a direct memory access controller, for the purpose of sending data to and receiving data
25 from the sequence controller 2, and an arithmetic circuit 101f comprising a so-called pulse distributing circuit which receives as inputs thereto signals indicative of amounts of movement X_0 , Y_0 along the X

and Y axes, respectively, and a signal indicative of feed speed F, for producing distributed pulses X_p , Y_p by performing a well-known arithmetic pulse distribution operation based on these signal inputs.

- 5 The numerical control device 1 also includes a manual data input unit (MDI) 101h that is mounted on the operator's panel of the numerical control device 1 for entering single blocks of machining command data when, say, adding to or modifying such data. Also provided
- 10 is a universal display unit 101i for displaying, e.g., the present position of a tool or the like. Note that the display unit and MDI may be constructed as a single unit. The aforementioned units are interconnected by a bus line 101g.
- 15 The PSC 2 comprises a programmer 201 for converting an entered sequence program into machine language and for correcting the sequence program, and a sequence controller cabinet 202. The programmer 201 includes a paper tape 201a bearing a correspondence
- 20 table (described below) and a sequence program in punched form, a paper tape reader 201b for reading the paper tape 201a, and a random access memory (RAM) 201c for storing the sequence program. A sequence program performs the function of a magnetics unit, expressing
- 25 the function thereof in logical form using operation codes and operands which make up a program. By way of example, a ladder diagram constituting part of the magnetics unit shown in Fig. 2 may be programmed as

depicted in Fig. 3. In Fig. 3, the operation codes in the sequence program are given by RD, AND, WRT, OR, AND NOT and so on. RD is a read operation instruction, AND a logical product instruction, WRT a write operation instruction, OR a logical sum instruction, and AND.NOT an instruction for logical multiplication with a negated value. Further, MF, M28, ..., AUT, M03... represent the operands of the sequence program and correspond to prescribed addresses and prescribed bits in a data memory 202a, described below, located within the sequence controller cabinet 202. The PSC 2, based on the group of instructions (1) shown in Fig. 3, executes the following logical operation:

MF $\overline{M28}$ $\overline{M24}$ $\overline{M22}$ $\overline{M21}$ $\overline{M18}$ $\overline{M14}$ M12 M11

and plants the result of the operation (either logical "1" or logical "0") in the data memory 202a at the prescribed bit of the prescribed address corresponding to operand M03. The PSC 2 also executes the following logical operation based on the group of instructions (2):

AUT M03 \overline{SPCCW}

and plants the result of the operation ("1" or "0") in the data memory 202a at the prescribed bit of the prescribed address designated by the operand SPCW.

Returning to Fig. 1, the programmer 201 further includes a correspondence table 201d for storing the corresponding relationships between the symbols MF, AUT... constituting the operands of the sequence

-5-

program, and storage locations of the data memory 202a.
An example of what is stored in the correspondence
table is illustrated in Fig. 4. It will be seen that
the symbol AUT corresponds to the first bit of the
5 tenth address of the data memory 10, that symbol M03
corresponds to the second bit of the tenth address, and
likewise through symbol CRA, which corresponds to the
second bit of the 42nd address. The ladder diagram of
Fig. 2 also shows the symbols matched with the
10 corresponding storage locations. The programmer 201 is
also provided with a read-only memory (ROM) 201e for
storing, e.g., a control program for controlling the
overall programmer 201, as well as a language
translator program for translating the sequence program
15 read in from the paper tape 201a into machine language.
The programmer 201 further comprises a central
processing unit (CPU) 201f for executing, e.g.,
translation and correction of the sequence program in
accordance with the program stored in the ROM 201e, and
20 a transceiving unit 201g having a buffer or the like
for sending data to and receiving data from the
sequence controller cabinet 202. The foregoing units
constituting the programmer 201 are interconnected by a
bus line 201h.

25 The sequence controller cabinet 202 includes the
data memory 202a mentioned above. The data memory 202a
establishes correspondence between each relay of the
magnetics unit shown in Fig. 2 and a single bit, the

on/off (closed/open) state of a relay being represented by logical "1" or logical "0", respectively, in the corresponding bit. For example, assume that the operator places the system in the automatic mode using the operator's panel. With a magnetics unit, the relay AUT in the power sequence circuit would be placed in the ON state. With the PSC, however, logical "1" is stored in the first bit of the tenth address in data memory 202a. The sequence controller cabinet 202 also includes a transceiving unit 202b having a buffer or the like for supervising the transmission and reception of data with the programmer 201, a RAM 202c for storing the sequence program translated into machine language by the programmer 201, a data input/output unit 202d for supervising the transmission and reception of data with the machine tool 3, a ROM 202e for storing the control program which controls the overall sequence controller cabinet 202, a central processing unit 202f for executing prescribed sequence processing in accordance with the control program and sequence program, and a transceiving unit 202g for sending data to and receiving data from the numerical control device 1. The units constituting the sequence controller cabinet 202 are interconnected by a bus line 202h.

Fig. 5 is a block diagram showing the data input/output unit 202d in greater detail. The data input/output unit 202d comprises a data input circuit DI and a data output circuit DO. The data input

-7-

circuit DI includes receivers R_1 through R_n which receive signals from various limit switches and relay contacts RC_1 through RC_n delivered from the machine side on cables l_{11} through l_{1n} , AND gates G_1 through G_n receiving the outputs of the respective receivers R_1 through R_n , and a decoder DEC_1 which decodes address signals received from an address bus ABUS to open predetermined ones of the AND gates, the AND gate output being sent out on the data bus DBUS. The data output circuit DO includes flip-flops (or latch circuits if desired) L_1 through L_m for storing such signals as forward and reverse spindle rotation signals obtained from the machine tool 3, drivers D_1 through D_m provided for corresponding ones of the flip-flops (flip-flop will be abbreviated to FF hereinafter) L_1 through L_m for delivering the output signals from the FFs to the machine tool 3 via cables l_{21} through l_{2m} to actuate the relays Ry_1 through Ry_m , and a decoder DEC_2 which decodes address signals received from the address bus ABUS to place predetermined ones of the FFs in a settable or resettable state, and which stores in predetermined FFs the data received from the data bus DBUS. In addition to the buses ABUS and DBUS, a control signal bus CBUS is provided for sending and receiving control signals. The abovementioned cables l_{11} through l_{1n} and l_{21} through l_{2m} interconnect the data input/output unit 202d and the machine tool so that data may be sent and received between them.

The PSC 2 operates in the following manner.

First, a table showing the correspondence between symbols and storage locations is prepared while referring to the ladder diagram (Fig. 2) of magnetics circuit, and the table is punched in a paper tape. A sequence program also is prepared in the above-described manner using operation codes and symbols (operands) and is similarly punched into the paper tape 201a. Next, the punched tape 201a is read by the paper tape reader 201b to store the correspondence table in table 201d and the sequence program in the RAM 201c.

When the foregoing has been accomplished the PSC 2 starts executing the language processing program stored in the ROM 201e, reads the instructions in the sequence program out of the RAM 201c in successive fashion and converts the operation codes and operands into machine language. The PSC uses the correspondence table to convert each operand into the machine word representing the prescribed address and bit of the data memory 202a.

The sequence program converted into these machine words is transferred to and stored in the RAM 202c through the transceiver unit 201g of the programmer 201 and the transceiver unit 202b of the sequence controller cabinet 202. The programmable sequence controller 2 now is capable of executing sequence processing.

Henceforth, in accordance with the control program, the CPU 202f reads the sequence program instructions successively out of the RAM 202c one instruction at a

time, executes sequence processing from the first to the last instructions of the sequence program and then returns to the first instruction to repeat the cycle. Thus the PSC 2 steps through the sequence program in
5 repetitive fashion.

Now assume that a command such as the command M03 for forward spindle rotation is issued by the numerical control device 101. When this takes place, with reference being had to Fig. 4, logical "1" is written
10 into the data memory 202a in the first bit of the 66th address where the M-function is to be stored, in the first bit of the 67th address where the M-code signal M11 is to be stored, and in the second bit of the 67th address where the M-code signal M12 is to be stored.

15 Since the central processing 202f is executing sequence processing by repeatedly stepping through the sequence program cyclically and reading out the instructions thereof in consecutive fashion, logical "1" will be stored in the fifth bit of the 20th address
20 of data memory 202a when the groups of instructions (1), (2) in the sequence program (Fig. 3) have been executed. Thereafter, the status (SPCW = "1") of the fifth bit at the 20th address is stored in, say, FF L₁ of the data output circuit DO (Fig. 5) and delivered to
25 the machine tool 3 through the driver D₁ and cable l₂₁. This item of data places the relay R₁ of the machine tool 3 in the ON state so that the spindle of the machine tool is rotated in the forward direction. Now

assume that, say, the relay contact RC1 on the machine tool side closes (i.e., assumes the ON state) during forward rotation of the spindle, thereby indicating completion of the rotation operation. As a result, a
5 forward rotation end signal (logical "1") from the machine tool side, which signal is produced by closure of the relay contact RC₁, is stored in a prescribed bit of the data memory 202a (Fig. 1) through the cable 1₁₁, receiver R₁, AND gate G₁ and data bus DBUS. Sequence
10 programming then continues and the numerical control device 1 is informed of completion of the forward rotation operation. This ends the sequence step for forward rotation of the spindle.

In the case described above the PSC 2 is provided
15 with the programmer 201. An arrangement as shown in Fig. 6 is possible, however, in which the programmer 201 and transceiver unit 202b are deleted, a sequence program already converted into machine language is read in from the numerical control device 1 by reading means
20 (such as the paper tape reader 101a') and is stored in the RAM 202c through the transceiver units 101e and 202g. In place of the RAM 202c, moreover, it is possible to use a ROM for storing a sequence program comprising machine language. Furthermore, while the
25 numerical control device 1 and PSC 2 are shown to be provided separately in Figs. 1 and 6, these can be integrated into a single unit and made to share the same processor, as illustrated in Fig. 7. In Fig. 7,

portions similar to those shown in Fig. 1 are designated by like reference characters. Numeral 101k denotes the abovementioned ROM for storing the sequence program expressed in machine language.

5 The numerical control system having the construction shown in Figs. 1, 6 and 7 is capable of displaying a ladder diagram on the universal display unit 101i in order to facilitate sequence program debugging and maintenance processing. When displaying
10 a ladder diagram in accordance with the prior-art method, however, the display unit does nothing more than display the relays of the ladder diagram and the memory locations at which the relay states ("1" or "0") are stored. This makes it difficult to understand the sequence processing
15 performed by the programmable sequence controller.

 According to one aspect of the invention there is provided a method of displaying a ladder diagram in a numerical control system having a programmable sequence control function in which sequence processing is executed based on a sequence program to
20 deliver commands from numerical control means to a machine and signals from the machine to the numerical control means, as well as a function for displaying the sequence program in the form of a ladder diagram
25 comprising at least relays, and for displaying storage locations of a data memory at each of which an operating state of a respective relay is stored, each storage location appearing in the vicinity of the relay corresponding thereto, said method comprising the steps of:

(a) storing in memory a corresponding relationship between each storage location at which the operating state of a respective relay is stored, and an identification of said relay;

5 (b) displaying a ladder diagram based on the sequence program and obtaining an identification of a relay by using the corresponding relationships and storage locations which are operands of respective instructions constituting the sequence program; and

10 (c) displaying a ladder diagram having the obtained relay identification appearing in the vicinity of the corresponding relay.

According to another aspect of the invention there is provided an apparatus for displaying a ladder
15 diagram in a numerical control system having a programmable sequence control function in which sequence processing is executed based on a sequence program to deliver commands from numerical control means to a machine and signals from the machine to the numerical control means,
20 as well as a function for displaying the sequence program in the form of a ladder diagram comprising at least relays, and for displaying storage locations of a data memory at each of which an operating state of a respective relay is stored, each storage location
25 appearing in the vicinity of the relay corresponding thereto, said apparatus comprising:

(a) a first memory storing the sequence program;

(b) a second memory for storing a corresponding relationship between each storage location at which the operating state of a respective relay is stored, and an identification of said relay;

5 (c) means for retrieving an identification of a relay by using the corresponding relationships and said storage locations which are operands of instructions constituting the sequence program; and

10 (d) display means for displaying a ladder diagram based on the sequence program and for displaying, in the vicinity of a corresponding relay, the retrieved relay identification and the storage location at which the operating state of said relay is stored.

15 An embodiment of the present invention may provide a method and apparatus for displaying a ladder diagram, wherein sequence processing is made easier to understand and both debugging and maintenance are greatly facilitated.

20 An embodiment of the present invention may provide a method and apparatus for displaying a ladder diagram in a numerical control system wherein it is possible to display not only the state of a relay but also the identification of the relay.

25 In an embodiment of the invention, corresponding relationships may be established between data memory locations storing the states (logical "1" or logical "0") of the relays, and the identifications of the relays. The corresponding relationships are stored in memory.

Then, by using these corresponding relationships, the identification of a desired relay may be found and displayed along with the relay, the identification appearing in the vicinity of the relay.

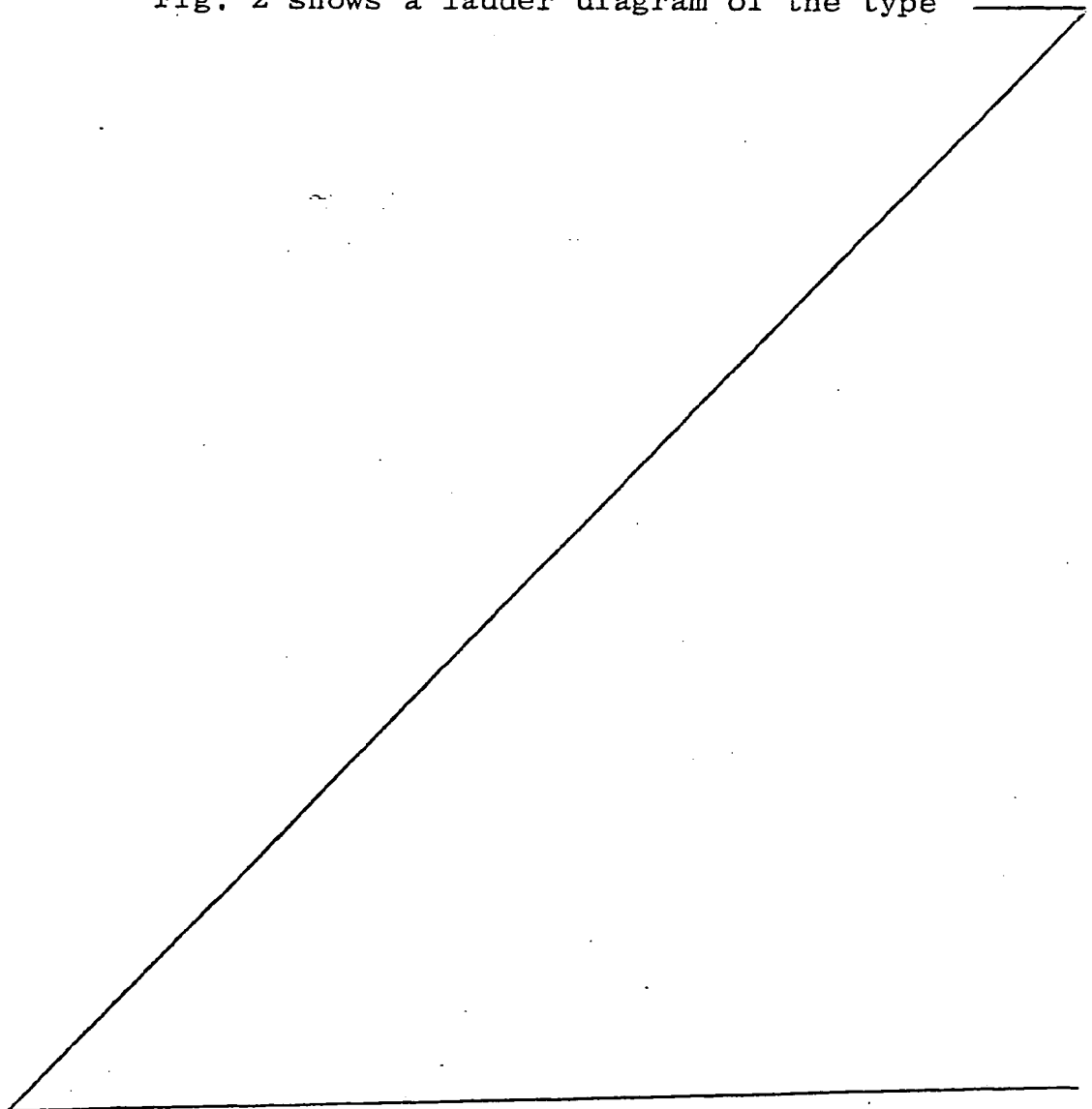
5

BRIEF DESCRIPTION OF THE DRAWINGS

Fig. 1 is a block diagram of an example of a programmable sequence controller according to the prior art;

10

Fig. 2 shows a ladder diagram of the type



associated with magnetics circuitry;

Fig. 3 illustrates an example of a sequence program;

Fig. 4 is an explanatory view showing the
5 corresponding relationship between symbols and storage locations in a memory;

Fig. 5 is a block diagram of a data input/output unit included in the programmable sequence controller shown in Fig. 1;

10 Figs. 6 and 7 are block diagrams illustrating examples of numerical control systems which include a programmable sequence control function;

Fig. 8 is a block diagram of a numerical control system for practicing a ladder diagram display method
15 according to an embodiment of the present invention;

Fig. 9 is an explanatory view of symbolic patterns stored in a character generator included in the system of Fig. 8; and

Fig. 10 is an explanatory view showing an example
20 of a display presented on the screen of a CRT included in the system of Fig. 8.

embodiment of the
In accordance with the present/invention,
corresponding relationships are established between
25 data memory locations storing the states (logical "1" or logical "0") of relays, and the identifications of the relays. The corresponding relationships are stored in memory. Then, by using these corresponding

relationships, the identification of a desired relay is found and is displayed along with the relay, the identification appearing in the vicinity of the relay.

Reference will now be had to Fig. 8 showing a
5 block diagram of a numerical control system for practicing a method of displaying a ladder diagram according to the present invention. The system includes a numerical control tape 301a bearing machining commands in punched form, a tape reader 301a'
10 for reading in the NC data from the tape 301a, a RAM 301b for storing the NC data read in by the tape reader 301a', a ROM 301c for storing a control program, a ROM 301d for storing a sequence program expressed in machine language, a data memory 301e comprising a RAM
15 for storing the results of numerical control processing and of sequence processing, and a table 301f for storing the corresponding relationships between relay identifications (symbols) written on a ladder diagram and locations (address and bit position) of the data
20 memory 301e storing the logical state ("1" or "0") of the relays. Also included are a manual data input device (MDI) 301g, a universal display unit 301h, and a data input/output unit 301i for supervising the input and output of data with the machine tool 3. It should
25 be noted that the data input/output unit 301i is structurally similar to the data input/output unit 202d shown in Fig. 5. Further provided is a pulse distributor 301j which receives as inputs thereto

signals indicative of amounts of movement X_o , Y_o along the X and Y axes, respectively, and a signal indicative of feed speed F, for producing distributed pulses X_p , Y_p by performing a well-known arithmetic pulse

5 distribution operation based on these signal inputs.

All of the foregoing units are under the control of a data processing unit 30lm, and all units are interconnected by a bus line 30ln.

The universal display unit 30lh comprises a
10 display controller DPC, a refresh memory RFM connected to the display controller DPC for storing the sequence program data transferred from the ROM 30ld following its conversion into picture information by the display controller DPC, a memory MEM for storing the
15 corresponding relationships transferred from the table 30lf, a character generator CG for storing various alphanumeric characters and symbolic patterns illustrative of a ladder diagram, a picture memory IMM for successively storing items of picture data
20 generated by the character generator CG based on the picture information, whereby all picture information for displaying a single frame is stored, and a drive DDV which receives the picture information output of the picture memory IMM for driving a cathode ray tube
25 CRT on the basis of the received information, whereby the CRT will display the stored picture.

As mentioned above, the character generator CG stores not only alphanumeric patterns but also symbols

for displaying ladder diagrams. Examples of these symbols are as shown in Fig. 9, in which (a) is a symbol indicating a normally open relay contact, (b) a symbol indicating a normally closed relay contact, and
5 so on through (m). Fig. 10 is an enlarged view of a segment of a ladder diagram when displayed on the screen of the cathode ray tube CRT.

When a request signal for display of a ladder diagram is entered by an input device such as the
10 operator's panel (not shown) or manual input device 30lg, the data processing unit 30lm transfers the corresponding relationships from table 30lf to the memory MEM of the universal display unit 30lh and then sends the sequence program data from the ROM 30ld to
15 the display side in sequential fashion. The unit of data delivered at one time comprises, say, the operation codes RD through WRT, as illustrated in Fig. 3. Upon receiving the sequence program data from the ROM 30ld, the display controller DPC edits the data
20 into picture information under the control of an editing program stored within the controller. For example, as shown in Fig. 10, the display controller DPC is adapted to divide one line into an identification display area, a symbolic display area
25 and an address display area and to generate picture information for each display area so that one line of picture information will be made up of the picture information in the three display areas. The

corresponding relationships stored in the memory MEM are used in generating the picture information for the identification display area. All picture information created by the display controller DPC is stored in the refresh memory RFM. Thereafter, the display controller DPC reads each item of picture information out of the refresh memory RFM in succession, reads the patterns corresponding to the picture information out of the character generator CG and stores the patterns in the picture memory IMM. Through these operations, ladder diagram segments are displayed on the cathode ray tube CRT.

embodiment of the

In accordance with the present invention as described and illustrated hereinabove, the identification of a relay is displayed along with the relay symbol and memory location storing the state of the relay, thereby facilitating an understanding of sequence processing and simplifying debugging and maintenance.

As many apparently widely different embodiments of the present invention can be made without departing from the spirit and scope thereof, it is to be understood that the invention is not limited to the specific embodiments thereof except as defined in the appended claims.

There has been disclosed
an apparatus for displaying a ladder diagram in a
numerical control system having a programmable sequence
controller function in which sequence processing is
5 executed based on a sequence program to deliver
commands from a numerical control device to a machine
and signals from the machine to the numerical control
device, as well as a function for displaying the
sequence program in the form of a ladder diagram
10 composed of at least relays, and for displaying storage
locations of a data memory at each of which an
operating state of a respective relay is stored, each
storage location appearing in the vicinity of the relay
corresponding thereto. Corresponding relationships are
15 established between data memory locations storing the
states (logical "1" or logical "0") of relays, and the
identifications of the relays. The corresponding
relationships are stored in memory. Then, by using
these corresponding relationships, the identification
20 of a desired relay is found and is displayed along with
the relay, the identification appearing in the vicinity
of the relay.

CLAIMS:

1. A method of displaying a ladder diagram in a numerical control system having a programmable sequence control function in which sequence processing is
5 executed based on a sequence program to deliver commands from numerical control means to a machine and signals from the machine to the numerical control means, as well as a function for displaying the sequence program in the form of a ladder diagram
10 comprising at least relays, and for displaying storage locations of a data memory at each of which an operating state of a respective relay is stored, each storage location appearing in the vicinity of the relay corresponding thereto, said method comprising the steps
15 of:
 - (a) storing in memory a corresponding relationship between each storage location at which the operating state of a respective relay is stored, and an identification of said relay;
 - 20 (b) displaying a ladder diagram based on the sequence program and obtaining an identification of a relay by using the corresponding relationships and storage locations which are operands of respective instructions constituting the sequence program; and
 - 25 (c) displaying a ladder diagram having the obtained relay identification appearing in the vicinity of the corresponding relay.
2. The method according to claim 1, in which the

operating state of a relay is represented by one-bit logic of "1" or "0".

3. The method according to claim 2, in which a storage location is specified by an address and a bit position.

5 4. An apparatus for displaying a ladder diagram in a numerical control system having a programmable sequence control function in which sequence processing is executed based on a sequence program to deliver commands from numerical control means to a machine and
10 signals from the machine to the numerical control means, as well as a function for displaying the sequence program in the form of a ladder diagram comprising at least relays, and for displaying storage locations of a data memory at each of which an
15 operating state of a respective relay is stored, each storage location appearing in the vicinity of the relay corresponding thereto, said apparatus comprising:

(a) a first memory storing the sequence program;

(b) a second memory for storing a corresponding
20 relationship between each storage location at which the operating state of a respective relay is stored, and an identification of said relay;

(c) means for retrieving an identification of a relay by using the corresponding relationships and said
25 storage locations which are operands of instructions constituting the sequence program; and

(d) display means for displaying a ladder diagram based on the sequence program and for displaying, in

the vicinity of a corresponding relay, the retrieved relay identification and the storage location at which the operating state of said relay is stored.

5 The apparatus according to claim 4, in which said
display means has means for dividing one line into an
identification display area, a symbolic display area
and an address display area and for generating picture
information for each display area, one line of picture
information being made up of the picture information in
10 the three display areas.

Fig. 1

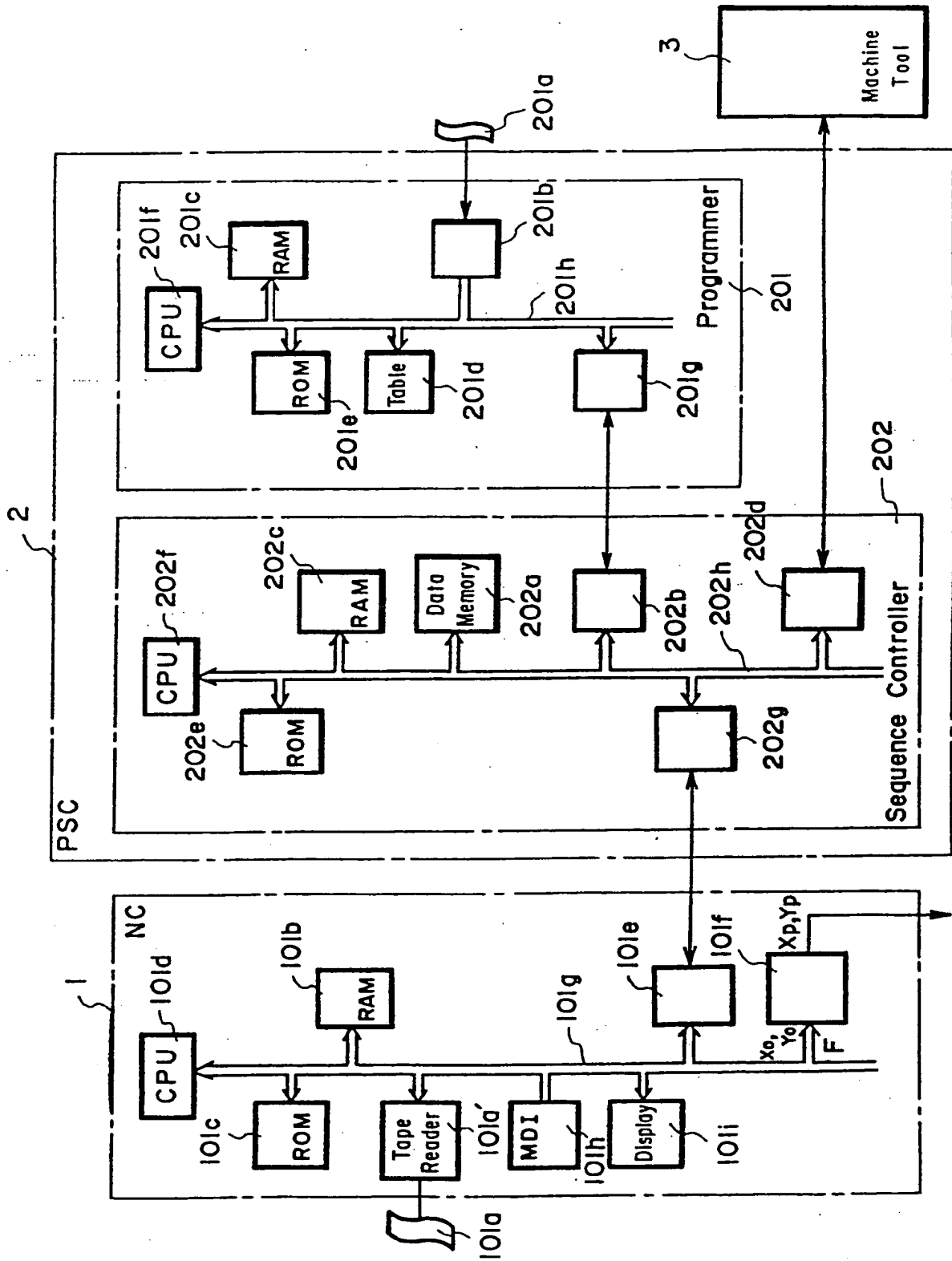


Fig. 2

0092312

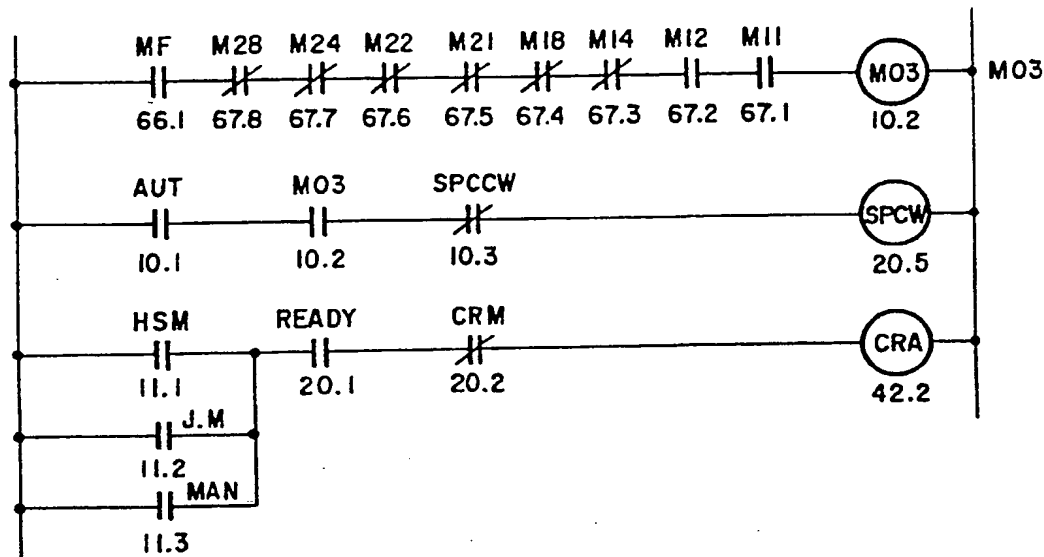


Fig. 3

Operation Code	Operand
RD	MF
AND.NOT	M 28
AND.NOT	M 24
AND.NOT	M 22
AND.NOT	M 21
AND.NOT	M 18
AND.NOT	M 14
AND	M 12
AND	M 11
WRT	M 03
RD	AUT
AND	M 03
AND.NOT	SPCCW
WRT	SPCW
RD	HS.M
OR	J.M
OR	MAN
AND	READY
AND.NOT	CRH
WRT	CRA

Fig. 4

Symbol	Data Memory Address and Bit	Symbol	Data Memory Address and Bit
AUT	10.1	MF	66.1
M03	10.2	M28	67.8
SPCCW	10.3	M24	67.7
SPCW	20.5	M22	67.6
HS.M	11.1	M21	67.5
J.M	11.2	M18	67.4
MAN	11.3	M14	67.3
READY	20.1	M12	67.2
CRH	20.2	M11	67.1
CRA	42.2		

Fig. 5

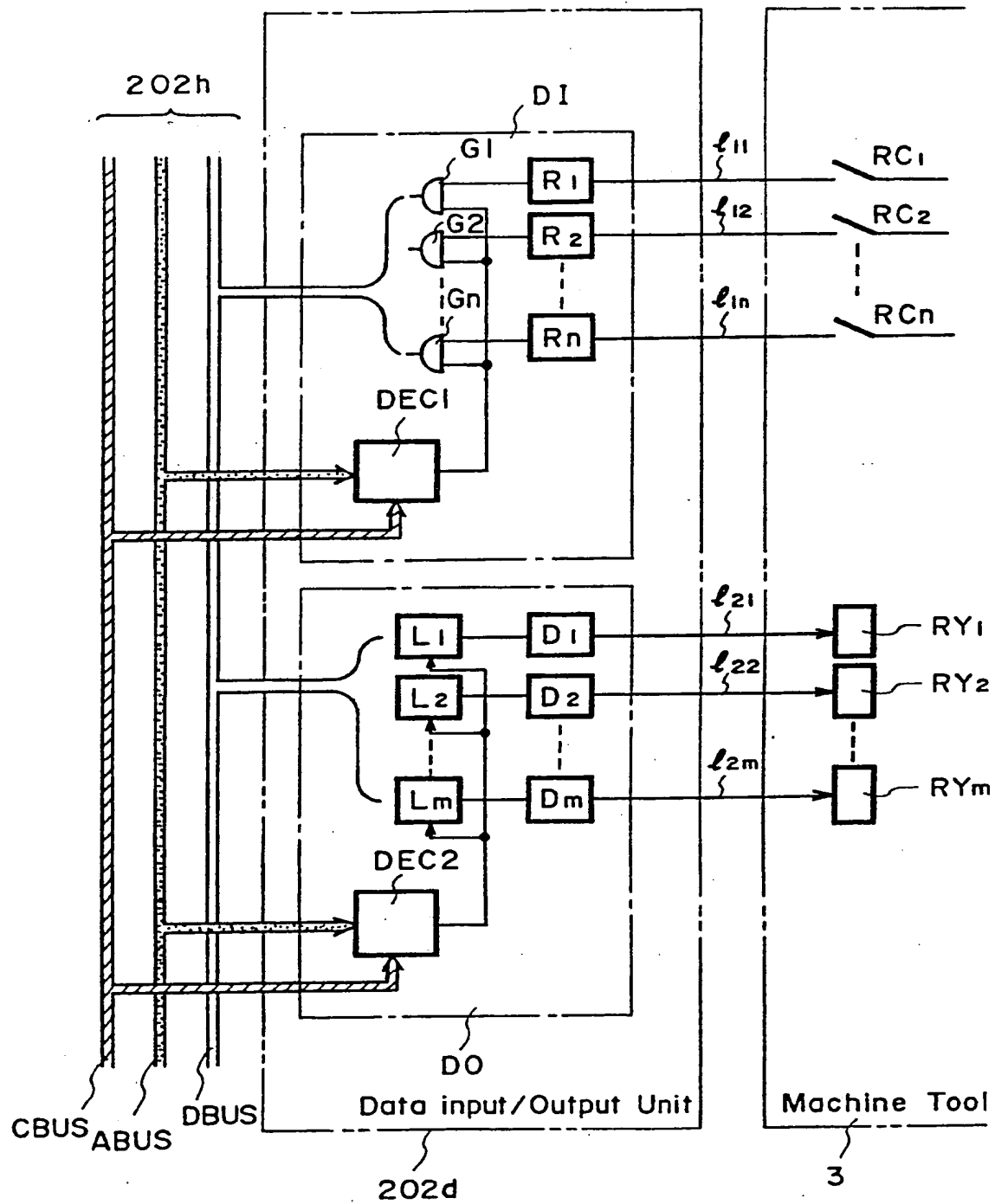
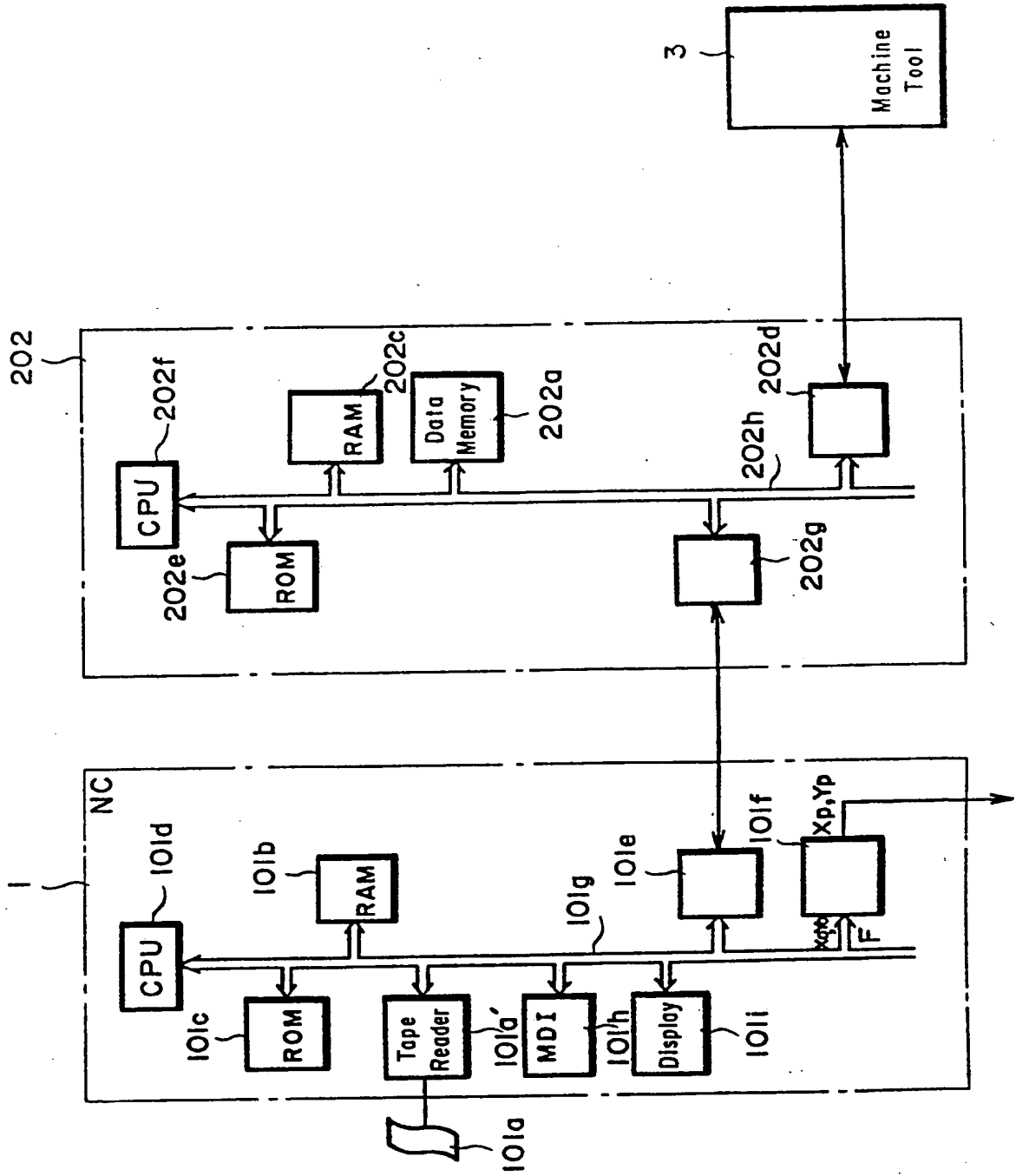


Fig. 6



உரி.

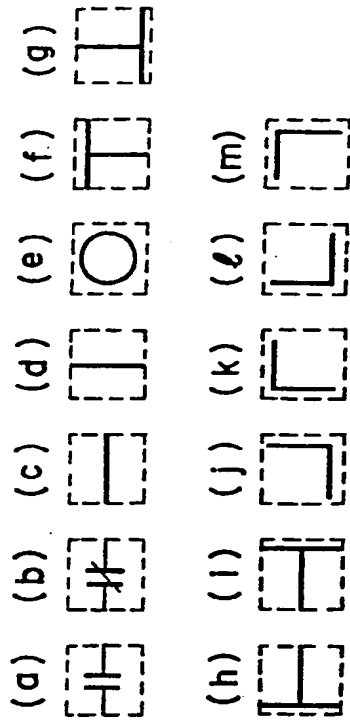


Fig. 10




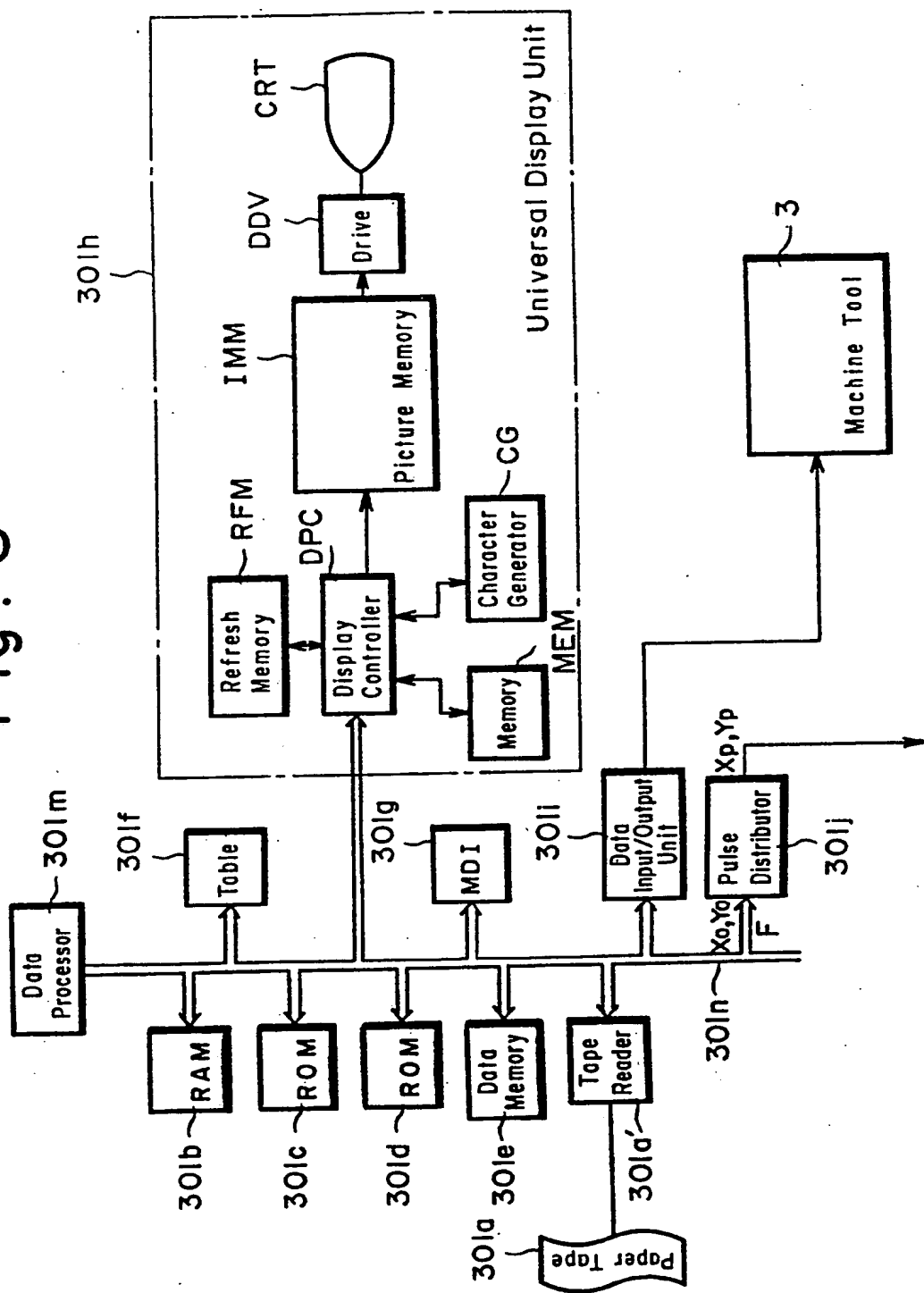
Identification	MF	M28	M03
Symbol			
Address	66.1	67.8	10.2

Fig. 8



-1- BASIC DOC.-



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(74) Representative: **Billington, Lawrence Emlyn et al, HASELTINE LAKE & CO Hazlitt House 28 Southampton Buildings Chancery Lane, London WC2A 1AT (GB)**(54) **Method and apparatus for displaying ladder diagrams.**

(57) An apparatus for displaying a ladder diagram in a numerical control system having a programmable sequence controller function in which sequence processing is executed based on a sequence program to deliver commands from a numerical control device to a machine and signals from the machine to the numerical control device, as well as a function for displaying the sequence program in the form of a ladder diagram composed of at least relays, and for displaying storage locations of a data memory at each of which an operating state of a respective relay is stored, each storage location appearing in the vicinity of the relay corresponding thereto. Corresponding relationships are established between data memory locations storing the states (logical "1" or logical "0") of relays, and the identifications of the relays. The corresponding relationships are stored in memory. Then, by using these corresponding relationships, the identification of a desired relay is found and is displayed along with the relay, the identification appearing in the vicinity of the relay.

Identification

Symbol

Address

	MF	M20		MO3	
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	66.1	67.0		10.2	

EP 0 092 312 A3



European Patent
Office

EUROPEAN SEARCH REPORT

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Application number

EP 83 30 1348

DOCUMENTS CONSIDERED TO BE RELEVANT			
Category	Citation of document with indication, where appropriate, of relevant passages	Relevant to claim	CLASSIFICATION OF THE APPLICATION (Int. Cl. 3)
A	US-A-3 944 984 (R.E. MORLEY, M.P. GREENBERG; MODICON) * Column 5, lines 29-48; column 17, lines 12-64; figure 6 *	1,4	G 05 B 19/04
A	FR-A-2 473 766 (TOYODA) * Page 2, line 10 - page 3, line 6; page 6, line 1 - page 8, line 35; figures 1,4,5 *	1,2,4	
A	US-A-4 038 533 (E. DUMMERMUTH et al.) * Abstract; column 22, line 45 - column 23, line 58; figure 10 *	1-4	
			TECHNICAL FIELDS SEARCHED (Int. Cl. 3)
			G 05 B
The present search report has been drawn up for all claims			
Place of search THE HAGUE		Date of completion of the search 13-06-1985	Examiner CORNILLIE O.A.R.
CATEGORY OF CITED DOCUMENTS			
X : particularly relevant if taken alone Y : particularly relevant if combined with another document of the same category A : technological background O : non-written disclosure P : intermediate document		T : theory or principle underlying the invention E : earlier patent document, but published on, or after the filing date D : document cited in the application L : document cited for other reasons & : member of the same patent family, corresponding document	

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